

Date: Friday, 18/07/2008 1:09:52 PM
User: Julie Lecocq

Process Sheet

Customer :	CU-DAR001 Dart Helicopters Services	Drawing Name :	HELI ACCESS HANDLE WELDMENT ASSY, LH
Job Number :	40637		
Estimate Number :	10946		
P.O. Number :		Part Number :	D2480011
This Issue :	18/07/2008	S.O. No. :	
Prsht Rev. :	NC	Drawing Number :	D2480 REV A1
First Issue :	/ /	Project Number :	N/A
Previous Run :	38292	Drawing Revision :	A1
	Type :	Material :	
	LARGE FAB ASSY	Due Date :	10/08/2008
Written By :		Qty:	4 Um: Each
Checked & Approved By :	JUL 08.7.18		
Comment :	Est. B1 03.01.09 added Powder Coat		

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	D2478	Heli-Access Handle
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 4.0000 Each(s)
Lower Arm

Pick:

Qty	Part number	Description	Batch
1	D2478	Heli Access Handle	B40632✓

Pl 08 08 13

2.0	D2479	Heli-Access Handle
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 4.0000 Each(s)
Upper Arm

Pick:

Qty	Part number	Description	Batch
1	D2479	Heli Access Handle	B40633✓

Pl 08 08 13

3.0	D2481	Mounting Plate
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Comment: Qty.: 2.0000 Each(s)/Unit Total : 8.0000 Each(s)
Lower Mount Plate

Pick:

Qty	Part number	Description	Batch
2	D2481	Mounting Plate	B40888✓

Pl 08 08 13

4.0	D2482	Mounting Plate
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 4.0000 Each(s)
Upper Mount Plate

Pick:

Qty	Part number	Description	Batch
1	D2482	Mounting Plate	B23504✓

Pl 08 08 13

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: HELI ACCESS HANDLE WELDMENT ASS'Y, LH

Job Number: 40637

Part Number: D2480011

Job Number:



Seq. #:

Machine Or Operation:

Description :

5.0

LARGE FAB 1

LARGE FABRICATION RESOURCE 1



Comment: LARGE FABRICATION RESOURCE 1

Weld as per Template DT 8333 (DT 2480 CJ)

Pl 08.08.13

(K4)

6.0

QC9

VISUAL WELDING INSPECTION



Comment: VISUAL WELDING INSPECTION

18/08/14 (4)

7.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

18/08.14 (4)

8.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

Powder Coat White Gloss (Ref: 4.3.5.2) as per QSI 005 4.3

START TIME:

OVEN TEMPERATURE:

FINISH TIME:

*3:20
3:00
3:50*

M. 08/08/14

(4x)

9.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

08-08-15

(XU)

10.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location:

PPP 40614

8/8/18

(4x)

SD

11.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

08/08/2008

Job Completion



MF 08-08-19

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

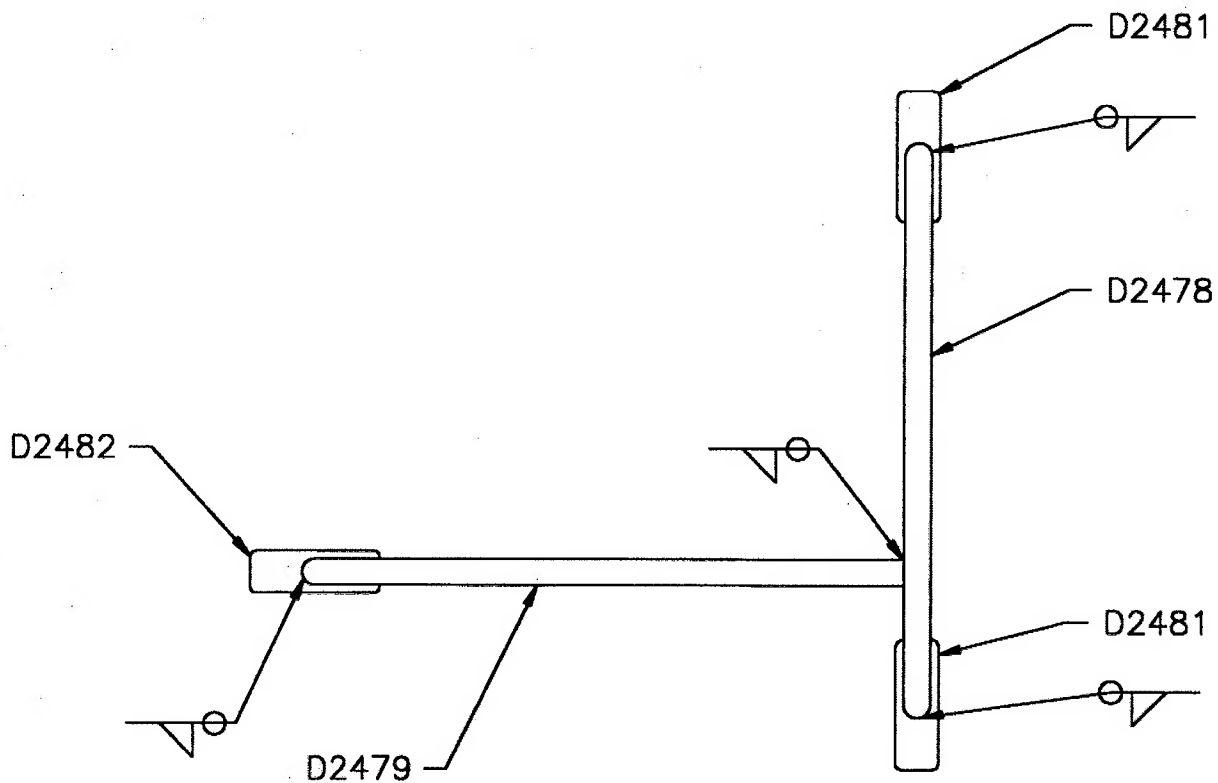
NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



DESIGN	DRAWN BY	DART AEROSPACE LTD VICTORIA INTERNATIONAL AIRPORT, CANADA	
B WILLIAMS	MIKE M	DRAWING NO.	REV. A
CHECKED <i>BW</i>	APPROVED <i>BW</i>	D2480	SHEET 1 OF 1
DATE	TITLE	SCALE	
96:05:14	HANDLE WELDMENT ASSEMBLY	6:1	
A1 11/11 05.06.23		ADDED POWDER COAT	

RELEASED
96/10/02 DS



D2480-011 LH SHOWN
D2480-012 RH OPPOSITE

NOTES:

- 1) WELD PER TEMPLATE DT 2480 WG PER QSI 004
2) POWDER COAT WHITE GLOSS (REF: 4.3.5.2) AS PER QSI 005

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 40637